

Work Order ID 120671

June-10-14 9:48:51 AM

ASAP
sup 12/06 *120671*

Page 1

Item ID: 646.3301 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Upper Cutter Assy
 Start Date: 6/10/14 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 6/11/14 Req'd Qty: 2.00 *2* Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 14-06-10 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
646.3300	N/C								

110 Pick Kit 0.00

110

Packaging

Memo

0.00

Packaging

2 0 0 AS
14-6-10

120

0.00

120

Small Fab

Memo

0.00

Small Fab

Two fastener must be install finger-tight (see note 9)

Assemble as per dwg and apply loctite 598 on all faying surfaces shown on dwg per note 7.

A/R. RTV LOCTITE 598: 127443
 exp. date: 10/15

2 0 0 AS
14-6-10

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Item ID: 646.3301 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Upper Cutter Assy
Start Date: 6/10/14 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 6/11/14 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 27 9-89 14/6/11				2			
140 *140* Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING THE P# AND REV***	0.00 0.00							DAS 32 9-89 2 14/6/11
150 *150* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							MW 14-6-12 14-6-12

Picklist Print

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Page 1

Work Order ID: 120671

120671

Parent Item: 646.3301

646.3301

Parent Item Name: Upper Cutter Assy

Start Date: 6/10/14

Required Date: 6/11/14

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 12.10.19 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
646.3310		Manufactured	No			110	Each	9.0000	1	2			
646.3310									**			AS 14-6-10	
LH Half													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				CA				9					
					108495			4					
					109916			5					
646.3311		Manufactured	No			110	Each	22.0000	1	2			
646.3311									**			AS 14-6-10	
RH Half													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				CA				22					
					100844			6					
					102840			8					
					107606			6					
					108423			2					
646.3312		Manufactured	No			110	Each	10.0000	1	2			
646.3312									**			AS 14-6-10	
Center Plate													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				CA				10					
					103083			4					
					103686			2					
					108244			4					

Picklist Print

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Work Order ID: 120671

120671

Parent Item: 646.3301

646 3301

Parent Item Name: Upper Cutter Assy

Start Date: 6/10/14

Required Date: 6/11/14

Start Qty: 2.00

Required Qty: 2.00

646.3313

Manufactured No

110

Each

18.0000

1

2

646 3313

Upper Guide

AS 14-6-10

Location

Loc Qty

Loc Code

CA

18

106094

2

109917

16

②

646.3314

Manufactured No

110

Each

10.0000

1

2

646 3314

Blade

AS 14-6-10

Location

Loc Qty

Loc Code

CA

10

108506

1

116347

9

②

646.3315

Manufactured No

110

Each

2.0000

1

2

646 3315

Blade

AS 14-6-10

Location

Loc Qty

Loc Code

CA

2

107680

2

②

646.3316

Manufactured No

110

Each

14.0000

1

2

646 3316

Blade

AS 14-6-10

Location

Loc Qty

Loc Code

CA

14

103515

2

116486

12

②

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Work Order ID: 120671

120671

Parent Item: 646.3301

646.3301

Parent Item Name: Upper Cutter Assy

Start Date: 6/10/14

Required Date: 6/11/14

Start Qty: 2.00

Required Qty: 2.00

NAS1149FN832P

Purchased

No

110

Each

9,564.000

36

72

NAS1149FN832P

AS 14-6-10

Washer

Location

Loc Qty

Loc Code

ST295

430

123185

30

123522

400

st510

9134

125268

9134

72

MS21042L08

Purchased

No

110

Each

5,144.000

18

36

MS21042L 08

AS 14-6-10

Nut

Location

Loc Qty

Loc Code

ST314

3211

123900

58

m128401

1500

m128429

1653

ST508

1834

125445

436

m127410

1398

36

ST509

99

m127304

99

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Work Order ID: 120671

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Parent Item: 646.3301

646.3301

Parent Item Name: Upper Cutter Assy

Start Date: 6/10/14

Required Date: 6/11/14

Start Qty: 2.00

Required Qty: 2.00

NAS1149F0332P

Purchased

No

110

Each

4,804.000

6

12

NAS1149F0332P

AL 14-6-10

Washer

Location

Loc Qty

Loc Code

GA

205

122063

205

ST295

1949

123900

12

m123185

34

m128401

1903

12

ST510a

2632

125646

132

m127831

2500

ST522

18

m123185

18

AN3-12A

Purchased

No

110

Each

47.0000

2

4

AN3-12A

AL 14-6-10

Bolt

Location

Loc Qty

Loc Code

ST351

45

m128398

38

m128687

7

4

ST511

2

m125709

2

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Work Order ID: 120671

120671

Parent Item: 646.3301

646.3301

Parent Item Name: Upper Cutter Assy

Start Date: 6/10/14

Required Date: 6/11/14

Start Qty: 2.00

Required Qty: 2.00

MS21042L3

Purchased

No

110

Each

6,016.000

3

6

MS21042L3

AS 14-6-10

Nut

Location

Loc Qty

Loc Code

ST314

109

108816

9

M127410

13

M127831

39

M128401

48

ST506

955

123900

955

ST509

4952

M127831

2

M128754

4950

6

MS27039-08-19

Purchased

No

110

Each

2,050.000

18

36

MS27039-08-19

AS 14-6-10

Screw

Location

Loc Qty

Loc Code

ST506

2050

124309

648

125654

127

m127410

275

m127904

1000

36

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Parent Item: 646.3301

646.3301

Parent Item Name: Upper Cutter Assy

Start Date: 6/10/14

Required Date: 6/11/14

Start Qty: 2.00

Required Qty: 2.00

AN3-14A

Purchased

No

110

Each

225.0000

1

2

AN3-14A

AS 14-6-10

Bolt

Location

Loc Qty

Loc Code

ST351

50

m127044

7

m128978

43

2

ST511

175

m127815

75

m128813

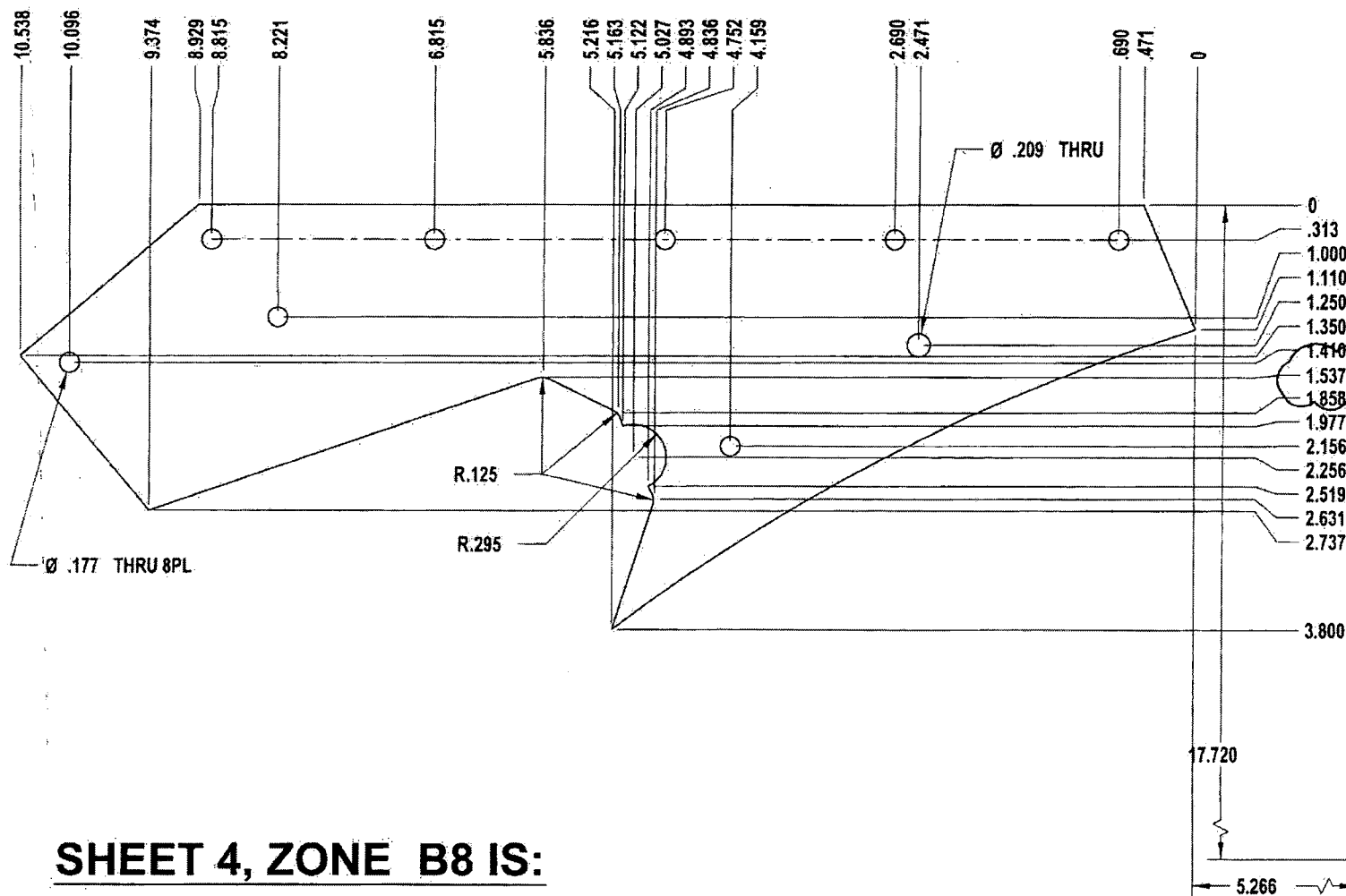
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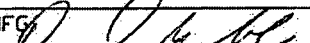
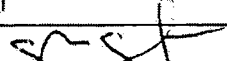
Page 6

APICAL INDUSTRIES, INC.	ENGINEERING CHANGE NOTICE NO. 03724				SHEET 1 OF 1	
	DWG NO. 646.3300	REV: N/C	PREPARED BY B. PETERS	DATE: 12/05/12	EFFECT ON DWG <input type="checkbox"/> INC. <input checked="" type="checkbox"/> UNINC.	
	DWG TITLE: UPPER CUTTER ASSY					
APPROVED BY: ENGR <i>[Signature]</i>		MFG <i>[Signature]</i>		QC <i>[Signature]</i>	EFF: NEXT ORDER	
TRANSACTION CODES (TC): A-ADD C-CREATE R-REVISE D-DELETE		REASON: REVISED ORDINATE DIMENSION.				ECR: D-12-025



SHEET 4, ZONE B8 IS:

DOCUMENTS EFFECTED:	<input type="checkbox"/> RFMS <input type="checkbox"/> MDL <input type="checkbox"/> INSTALL INSTRU <input type="checkbox"/> ICA <input type="checkbox"/> BOM	CHANGE CATEGORY <input type="checkbox"/> MAJOR <input checked="" type="checkbox"/> MINOR	DER REVIEW REQUIRED <input type="checkbox"/> YES <input checked="" type="checkbox"/> NO
---------------------	--	---	--

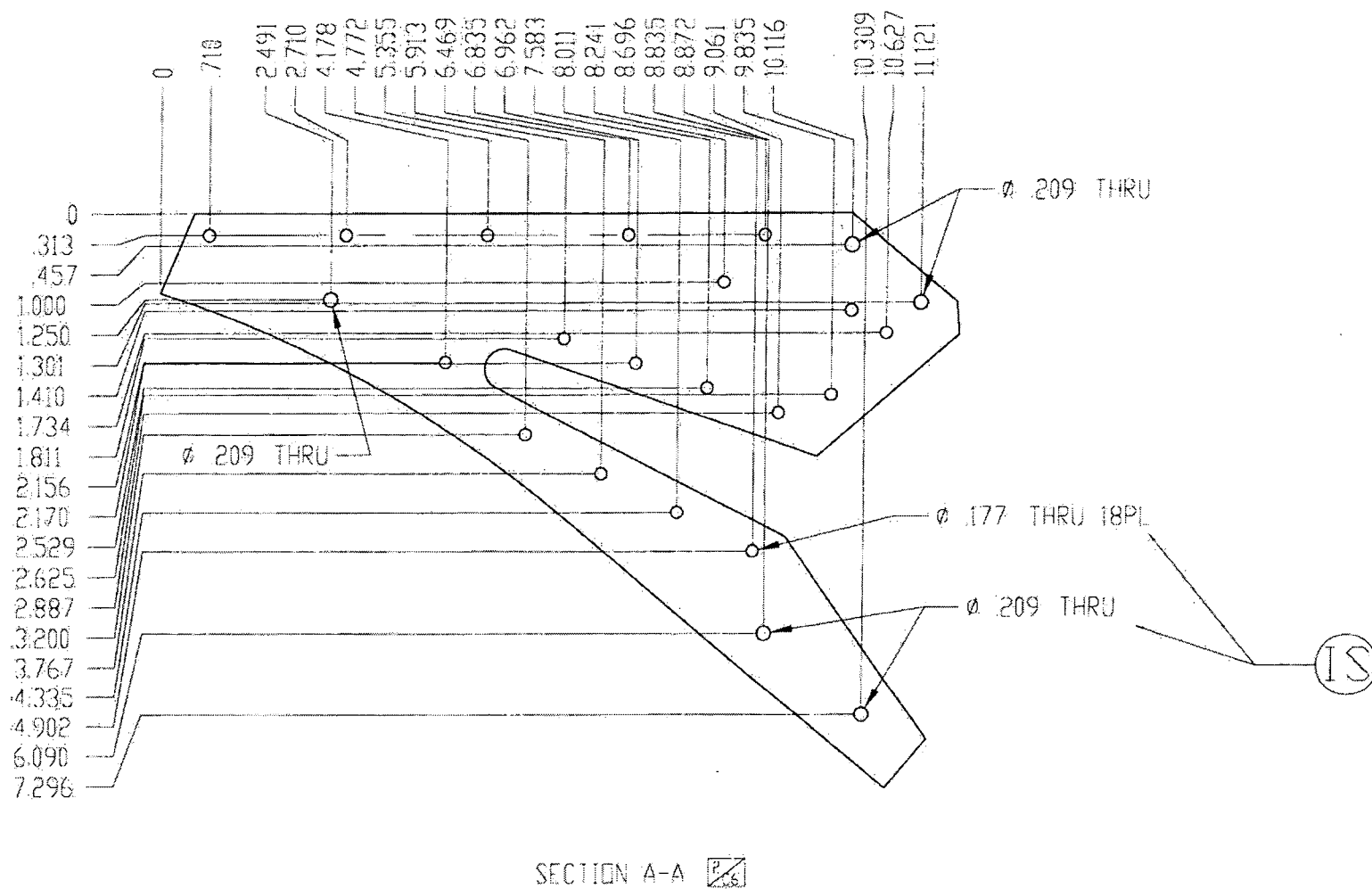
ENGINEERING CHANGE NOTICE NO.		02196		SHEET 1 OF 2	
DWG NO. 646.3300		REV: N/C		PREPARED BY S. HUFF	DATE: 01/05/09
				EFFECT ON DWG <input type="checkbox"/> INC. <input checked="" type="checkbox"/> UNINC.	
DWG TITLE:		UPPER CUTTER ASSY			
APPROVED BY:	ENGR 	MFG 	QC 	EFF: NEXT ORDER	
REASON: REMOVED RIVETS IN FAVOR OF ADDITIONAL SCREWS					

646.3301, IS:

646.3301
SHOWN EXPLODED

14	R	601.2765		18	SCREW	MS27039-0819
10	R	601.1541		18	LOCKNUT	MS21042L08
9	D	601.2766		3	RIVET	MS20470AD5-18
8	R	601.2764		36	WASHER	NAS1149FN832P
				.3301		
F/N	TC	PART NUMBER	QTY	DESCRIPTION		MATERIAL/SPECIFICATION
DOCUMENTS EFFECTED:						CHANGE CATEGORY <input type="checkbox"/> MAJOR <input checked="" type="checkbox"/> MINOR
<input type="checkbox"/> MDL <input checked="" type="checkbox"/> INSTALL INSTRUC <input checked="" type="checkbox"/> ICA <input type="checkbox"/> FMS <input checked="" type="checkbox"/> BOM						DER REVIEW REQUIRED <input type="checkbox"/> YES <input checked="" type="checkbox"/> NO

SHEET 3, SECTION VIEW A-A, IS:



F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL/SPECIFICATION

REVISIONS			
REV.	DESCRIPTION	DATE	APPROVE



02196, 037.24

1 MATERIAL: ALUMINUM 7075-T651 PER AMS-QQ-A-250/12

△2 FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III,
CLASS 2, COLOR BLACK;
CARDINAL 4860-50 PRETREATMENT PRIMER
PRIME IAW MIL-P-23377J TYPE I CLASS N

3 MATERIAL: AISI A2 TOOL STEEL
CONDITION: ANNEALED
POST PROCESS: HEAT TREAT TO 58-62 Rc ROCKWELL HARDNESS

4 FINISH: PRIME IAW MIL-P-23377J TYPE I CLASS N

5. DEBURR AND BREAK ALL SHARP EDGES EXCEPT WHERE OTHERWISE NOTED

6. IDENTIFY IAW MPP-120

7 APPLY F/N 15 AS REQUIRED TO ALL FAYING SURFACES OF F/N 5, 6 & 7 UPON ASSEMBLY

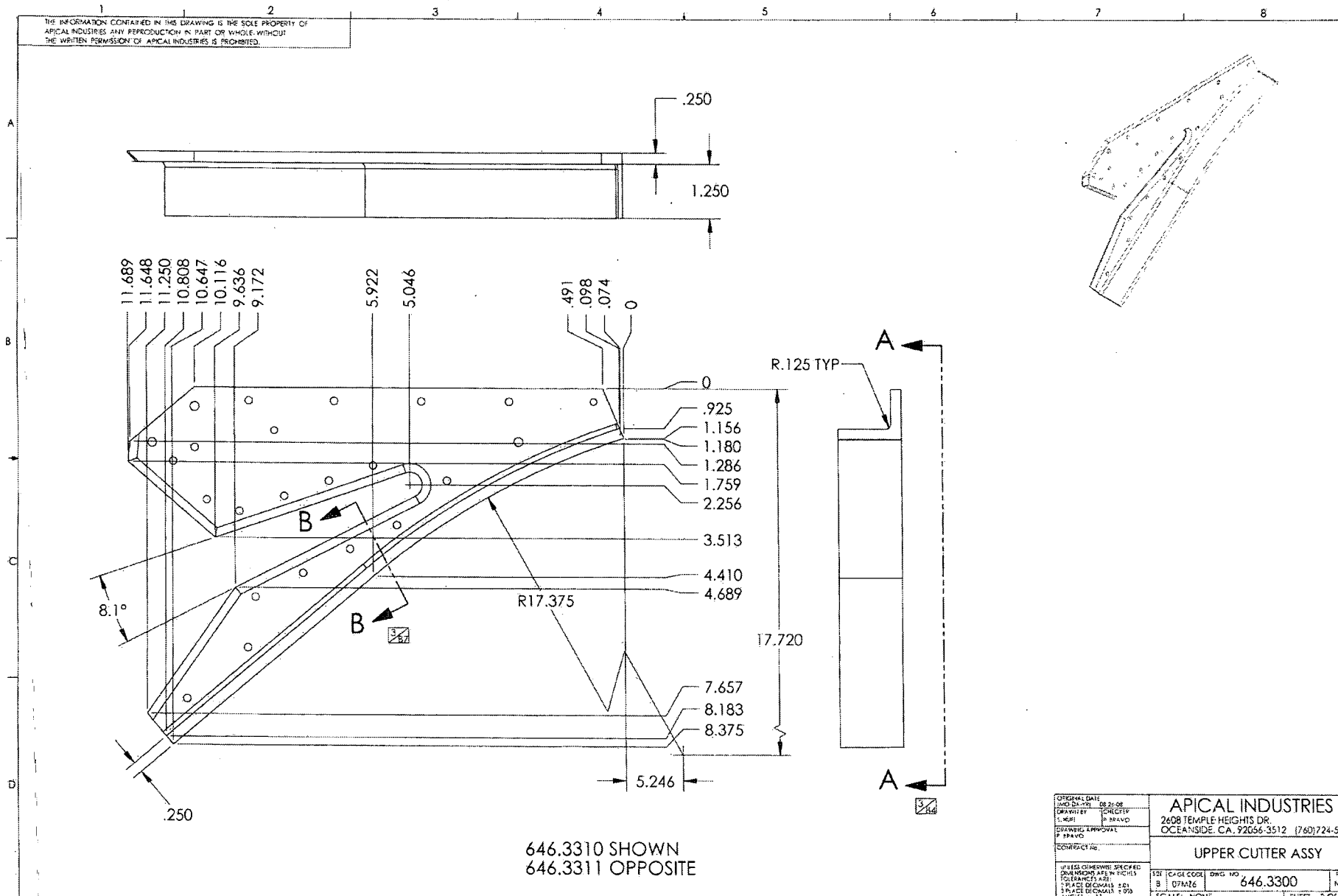
8 CUTTING EDGE INTENDED TO BE SHARP, DO NOT BREAK SHARP EDGE

9. INSTALL FASTENER FINGER-TIGHT

646.3301
SHOWN EXPLODED

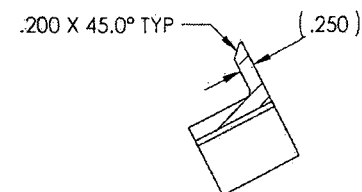
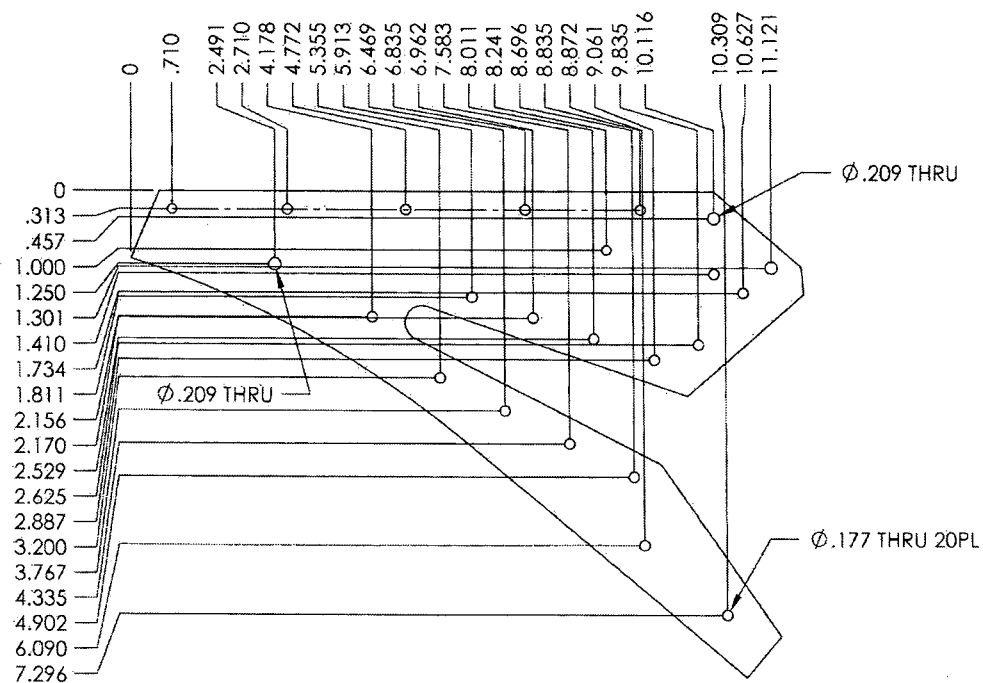
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THE WRITTEN PERMISSION OF APICAL INDUSTRIES IS PROHIBITED.



ORIGINAL DATE DWG. DATE: 08-20-08		APICAL INDUSTRIES	
DRAWN BY: T. HUNT		2608 TEMPLE HEIGHTS DR.	
CHECKED BY: P. BRAYVO		OCEANSIDE, CA. 92056-3512 (760) 724-5300	
DRAWING APPROVAL P. BRAYVO		UPPER CUTTER ASSY	
ELECTRICITY NO.		151 (CAGE CODE) DWG. NO. 646.3300	
IF BESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: FRACTIONS DECIMALS ANGLES 1/16 0.0001 1/16 0.0001 1/16 0.0001		BY: N/C	
SCALE: NONE		SHEET 2 OF 8	

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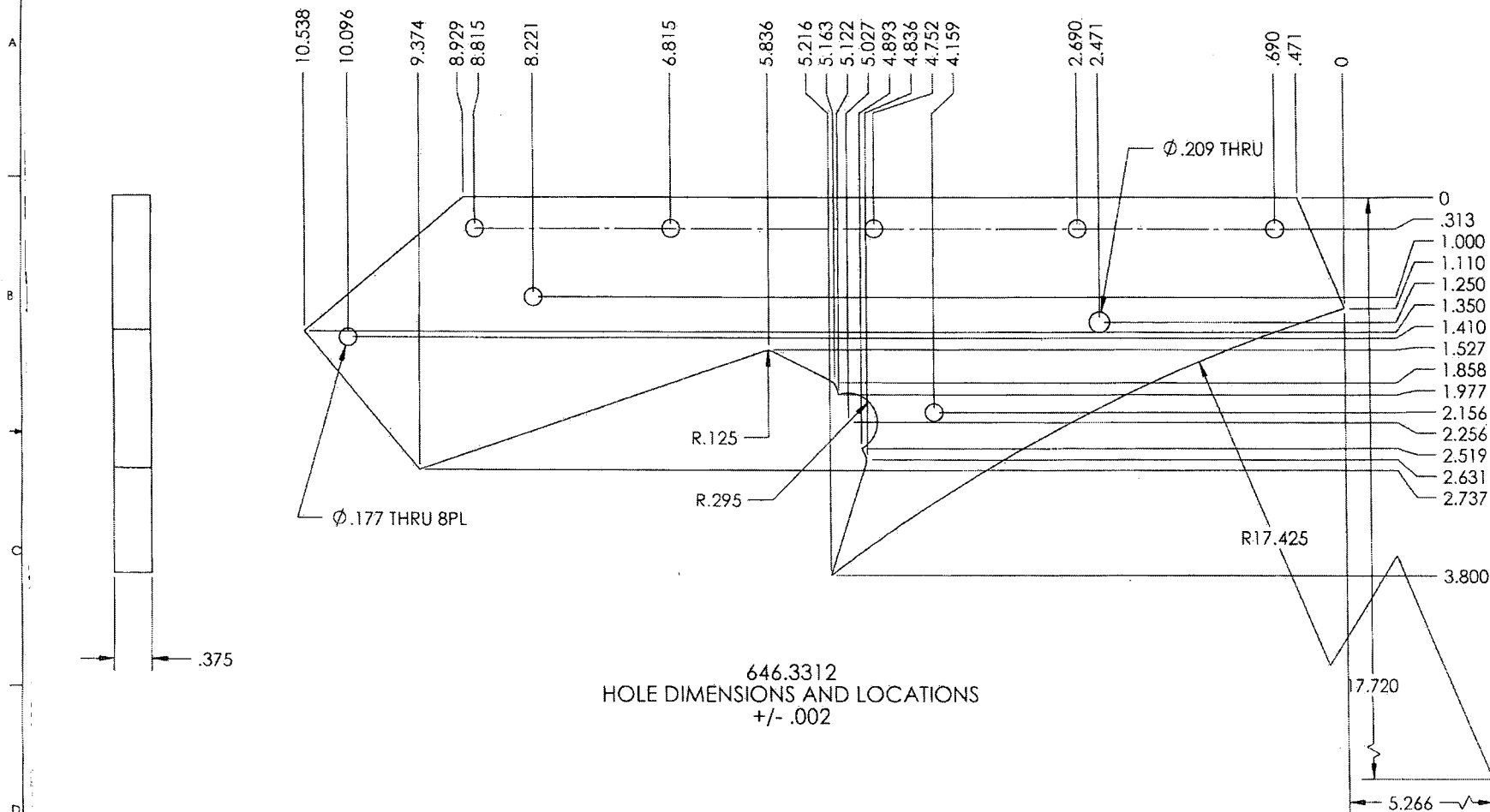
SECTION B-B

SECTION A-A

ORIGINAL DATE (DD-MY-YY) 09-26-08		APICAL INDUSTRIES	
DRAWN BY S. MUIP		2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
CHECKED BY P. BAVID		UPPER CUTTER ASSY	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°		1ST CHGT CODE B 07/02/16	END. NO. 646.3300
		SCALE NONE	REV NYC
		SHEET 3 OF 8	

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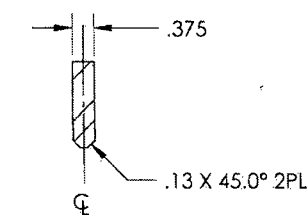
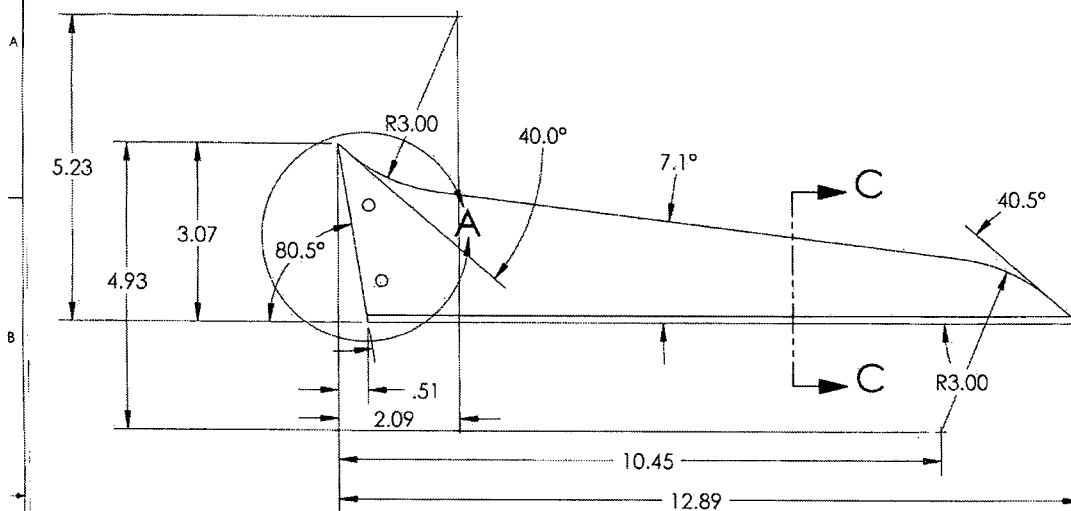
REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED



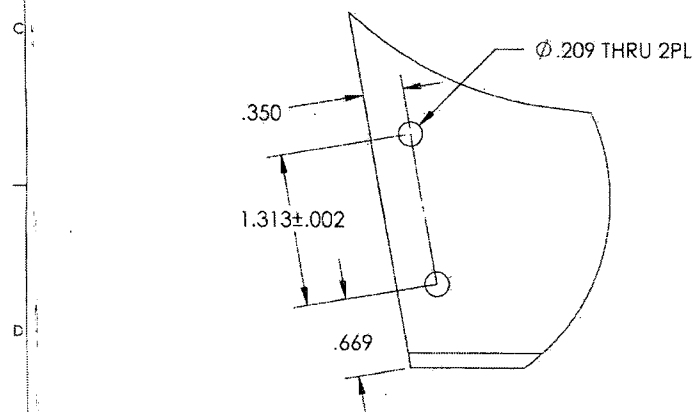
ORIGINAL DATE MAY-04-01 09-22-09		APICAL INDUSTRIES	
DRAWN BY S. HUI	CHECKED BY P. BRAVO	2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWING APPROVAL P. BRAVO		UPPER CUTTER ASSY	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: FRACTIONS DECIMALS ± .01 ANGLES ± .5°		REV. 8	REV. N/C
SCALE: NONE		SHEET 4 OF 8	

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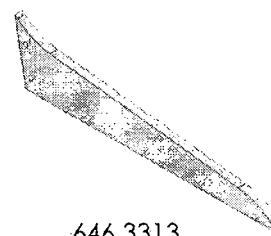
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REV	DESCRIPTION	DATE	APPROVED



SECTION C-C



DETAIL A

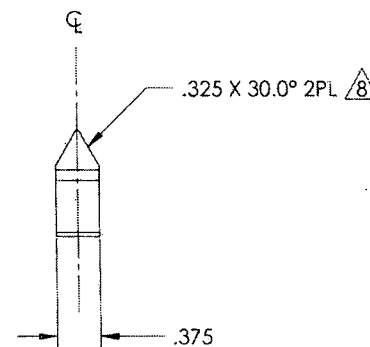
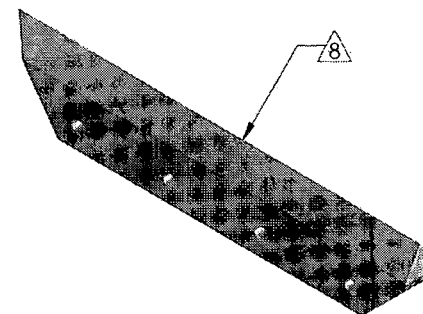
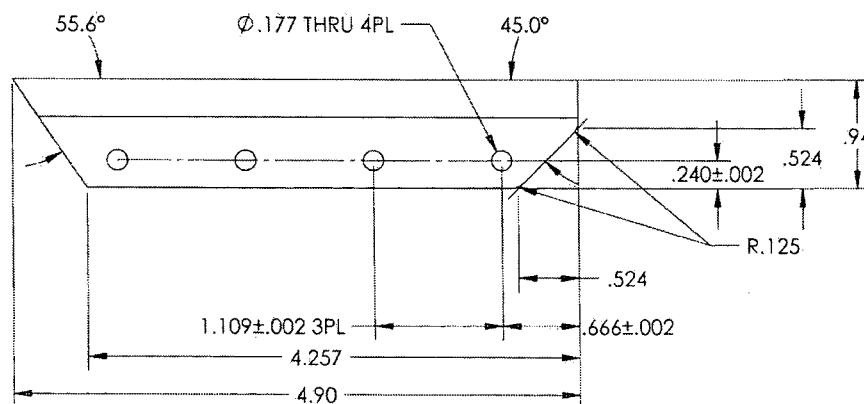


646.3313

ORIGINAL DATE 10/01/01		DESIGNED BY S. HUFF	
DRAWN BY P. BRAVO		CHECKED BY P. BRAVO	
APPROVED BY P. BRAVO		DATE 10/01/01	
TOLERANCES UNLESS SPECIFIED DIMENSIONS ARE IN INCHES FRACTIONS ARE: 1/16, 1/8, 3/16, 1/2, 5/8, 3/4, 7/8 DECIMALS ARE: .005, .010, .015, .020, .025, .030, .035, .040, .045, .050, .055, .060, .065, .070, .075, .080, .085, .090, .095, .100		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
UPPER CUTTER ASSY		PART NO. 646.3300	
SCALE: NONE		SHEET: 5 OF 8	

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REVISION			
REV.	DESCRIPTION	DATE	APPROVED

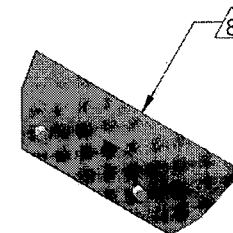
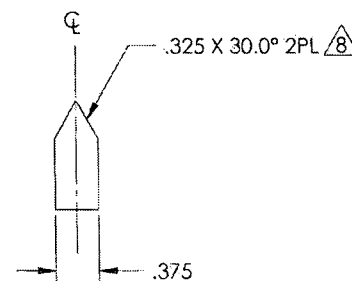
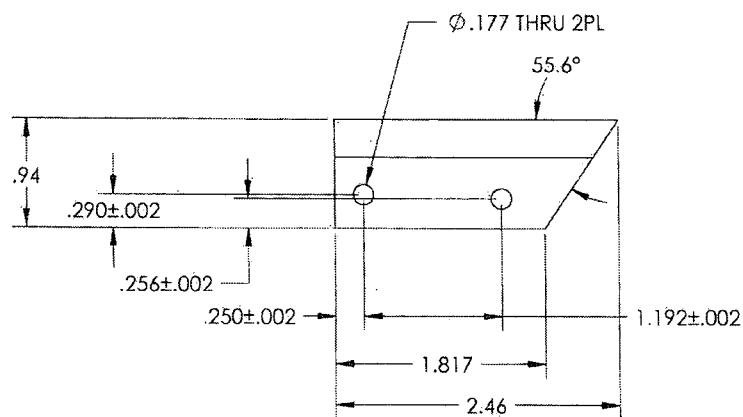


646.3314

ORIGINAL DATE INSTRUMENT DRAWN BY S. HUFF DRAWING APPROVAL P. BRAVO DATE C. HUFF		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES FRACTIONS ARE DECIMALS ±.01 ANGLES ±.5°		UPPER CUTTER ASSY	
REV B	CAGE CODE 07M26	QTY 646.3300	REV N/C
SCALE NONE		SHEET 6 OF 8	

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REVISION		DATE	APPROVED
REV	DESCRIPTION		

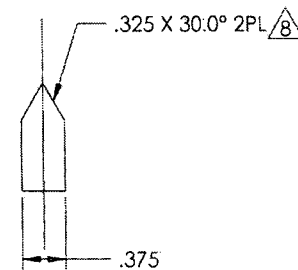
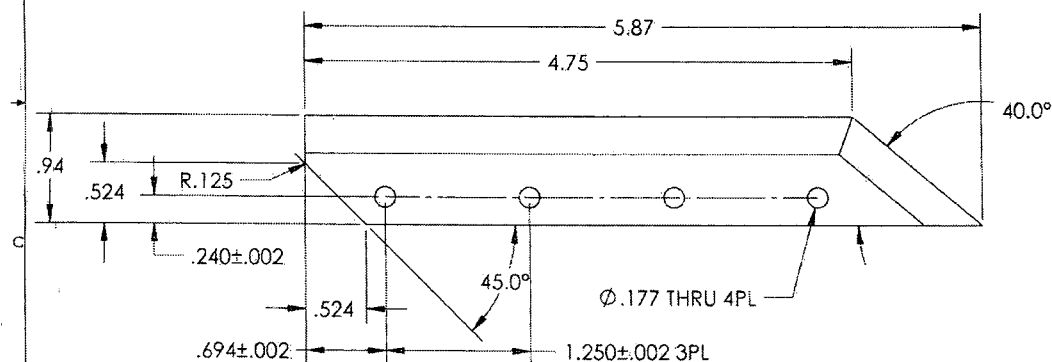


646.3315

ORIGINAL DATE INCHES: .001 SHEET: 1 DRAWING APPROVAL P. BRAND DATE: 08-26-08 CUTTER CT NO		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 1 PLACE DECIMALS $\pm .01$ 2 PLACE DECIMALS $\pm .005$ ANGLES $\pm .5^\circ$		UPPER CUTTER ASSY	
REV	DATE	QTY	REV
8	07/16	646.3300	N/C
SCALE: NONE		SHEET 7 OF 8	

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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED



646.3316

ORIGINAL DATE 10/24/91 (PR) 05-26-08 DESIGNED BY P. HOFFER CHECKED BY S. HUFF P. BRAVO	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300		
DRAWING APPROVAL P. BRAVO 05-26-08	UPPER CUTTER ASSY		
CONTRACT NO.			
WHEN OTHER PRICE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 3 PLACE DECIMALS ±.01 2 PLACE DECIMALS ±.005 ANGLES ±.5°	SEE CASE 5024 8 07/26 SCALE NONE	DWG NO 646.3300	REV. N/C
		SHEET 8	OF 8